

Date: Thursday, 2/9/2006 1:55:05 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT
Job Number :	25784		
Estimate Number :	12140		
P.O. Number :	N/A	Part Number :	D206731042
This Issue :	2/9/2006	Drawing Number :	IIN-D206-731 <i>pg 4,6</i>
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	25783	Material :	N/A
Written By :	<i>[Signature]</i>	Due Date :	3/30/2006
Checked & Approved By :	<i>[Signature]</i> 06.02.10	Qty:	1 Um: Each
Comment :	est rev. A 01.02.01 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓	qty	Part Number	Description	batch
	1	D3335-5	spring	B25909

Cpl 06.12.07

2.0	D3353041	LUG ARM WELDMENT
-----	----------	------------------



✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓	qty	Part Number	Description	batch
	1	D3353-041	LUG ARM WELDMENT	B28316

Cpl 06.12.07

3.0	D3354042	MIRROR ARM WELDMENT
-----	----------	---------------------



✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓	qty	Part Number	Description	batch
	1	D3354-042	Left Arm Weldment	B25911

Cpl 06.12.07

4.0	D33561	pin
-----	--------	-----



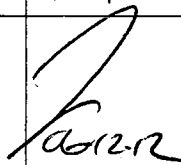
✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

✓	qty	Part Number	Description	batch
	1	D3356-1	pin	B25912

Cpl 06.12.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-12-11	4.1	Add D3354-043 Qty 1 Perm. chg.	batch: 327883 06-12-11	06-12-11	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:55:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25784

Part Number: D206731042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D3397041	wheel ass'y
-----	----------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	B25804

QPL 06.12.07

6.0	113800	GREASE FITTING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	M101058

QPL 06.12.07

7.0	656051	flat washer
-----	--------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	M17413

QPL 06.12.07

8.0	663079	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	M16362

QPL 06.12.07

9.0	AN523A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	M19278

QPL 06.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:55:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25784

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 AN960JD516L Washer *M17619*

QPL 06.12.07

11.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty Part Number Description batch

2 ~~SNF-34~~ *CP21* 1/8" Cotter Pin 2" long *M16301*

QPL 06.12.07

12.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 MS21042L5 Nut *M102171*

QPL 06.12.07

13.0

SNF34

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty Part Number Description batch

1 SNF-34 ~~1/8" Cotter Pin 2" long~~ *M16354*

2 *Stop Nut*

QPL 06.12.07

14.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 TP-2 Spring pin *M16588*

QPL 06.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: TD Date: 20/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:55:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25784

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

qty Part Number Description
1 TP-134 Spring pin

batch

716362

CP 06-12-07

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

CP 06-12-11

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 12-12 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 321*

CP 06/12/12 ①

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

CP 06/12/12 ①

Job Completion



CP 06/12/12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

4.0 PARTS LIST

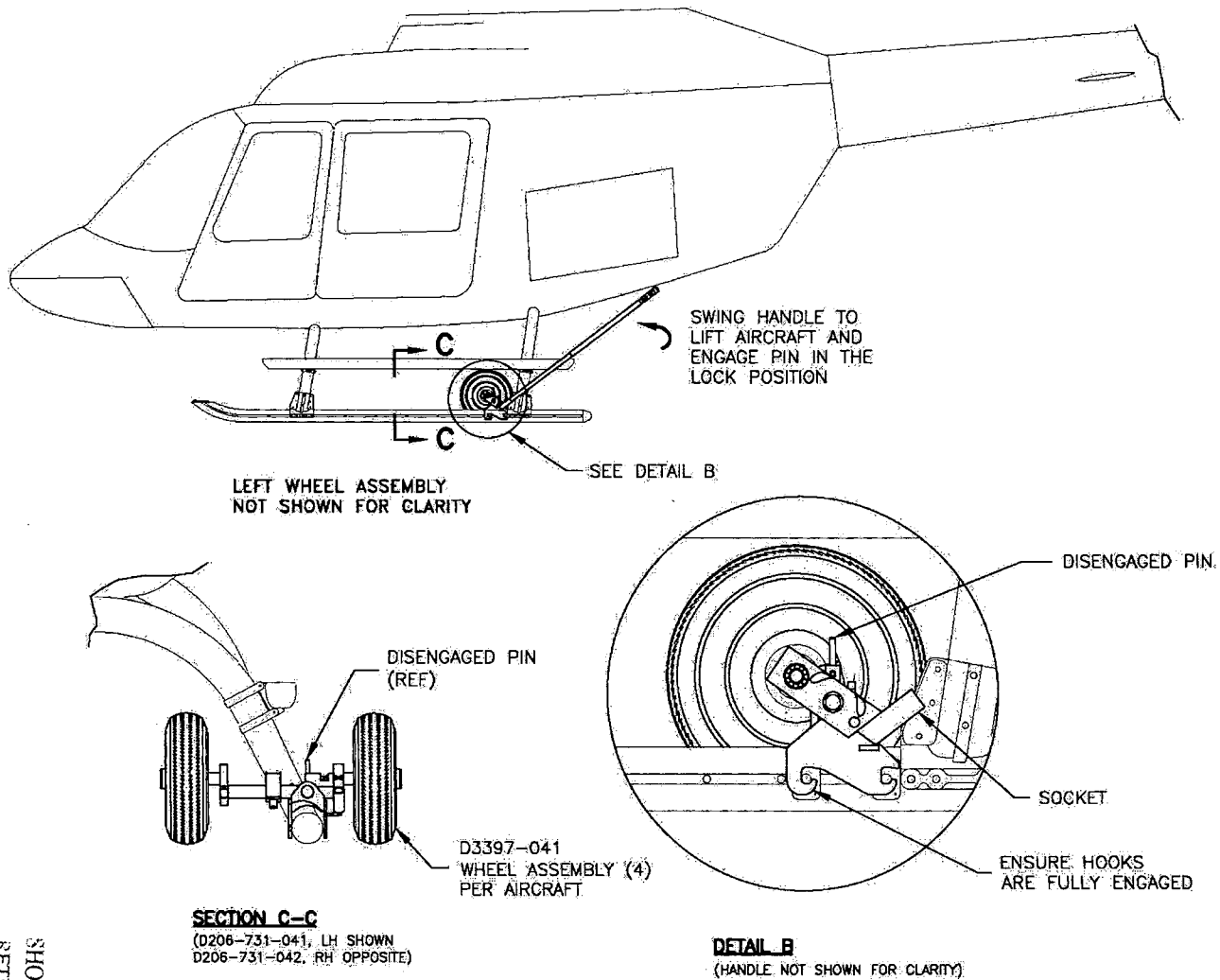
QTY -011	QTY -041	QTY -042	Part Number	Description
X			D206-731-011	MECHANICAL GROUND HANDLING WHEEL KIT
1	X		D206-731-041	MECHANICAL GROUND HANDLING WHEEL (LH)
1		X	D206-731-042	MECHANICAL GROUND HANDLING WHEEL (RH)
	1	1	D3335-5	* SPRING
		1	D3353-041	* LUG ARM WELDMENT
	1		D3353-042	* LUG ARM WELDMENT
	1		D3354-041	* LEFT ARM WELDMENT
		1	D3354-042	* MIRROR ARM WELDMENT
1			D3355-041	* HANDLE ASSEMBLY
	1	1	D3356-1	* PIN
	2	2	D3397-041	* WHEEL ASSEMBLY
1			D3381-1	** LABEL
	1	1	113-800	* GREASE FITTING
	2	2	656-051	* FLAT WASHER
	1	1	663-079	* LOCK WASHER
	1	1	AN5-23A	* BOLT
	1	1	AN960JD516	* WASHER
	2	2	CP-21	* COTTER PIN
	1	1	MS21042L5	* NUT
	2	2	SNF-34	* SLOTTED NUT
	1	1	TP-2	* SLOTTED SPRING TENSION PIN
	1	1	TP-134	* SLOTTED SPRING TENSION PIN

* shown for reference only, part is included in D206-731-041/ -042 assemblies above

** shown for reference only, part is included in D3355-041 assembly above

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PRELIMINARY DRAWING



**Figure 2 – D206-731-041 Mechanical Ground Handling Wheel Installation
(Left Side Shown, Right Side Opposite)**

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